

Date: Tuesday, 3/11/2008 7:57:21 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB ASSEMBLY
Job Number : 37741	
Estimate Number : 10194	
P.O. Number :	Part Number : D2174041
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2174 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 32856	Material :
Written By : <u>AD 08 03 11</u>	Due Date : 4/4/2008 Qty: <u>12</u> Um: Each
Checked & Approved By :	
Comment : Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM	
Est Rev:E As per Rev E 06-11-22 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D21741	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s) 12  
 Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	<u>B31689</u> (2)

~~B37848~~ B37848

SB 08/04/01 (12)

2.0	D21751	Angle LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s) 12  
 Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	<u>B31691</u>

SB 08/03/25 (12)

3.0	D21752	Angle RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s) 12  
 Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	<u>B35342</u>

SB 08/03/25 (12)

4.0	MS20470AD46	Rivet, Universal Head
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Comment: Qty.: 19.0000 Each(s)/Unit Total : ~~190.0000~~ Each(s) 228 Rivets  
 Rivet, Universal Head ✓

Qty	Part Number	Description	Batch
19	MS20470AD46	Rivet	<u>M106375</u> x13

M 107082 x 215

M 08/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:21 AM  
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Drawing Name: WEB ASSEMBLY

Job Number: 37741

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

*ml 08/04/01 (X12)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 08/04/01 (X12)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m 107550*

*AS 08-04-02*

*(12)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*m-1 08/04/02*

*(12X)*

9.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

Batch: *9216*

*AS 08/04/03*

*(X12)*

10.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Batch: *M107091*

*AS 08/04/03*

*(X12)*

11.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

Batch: *M106903*

*AS 08/04/03*

*(X12)*

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install nuts & bolts loosely as per Dwg D2274

*CB 08/04/03 (12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:21 AM  
User: Kim Johnston

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Drawing Name: WEB ASSEMBLY

Job Number: 37741

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/08 x12

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST222

AS 08/04/08 x12

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08 x12

Job Completion



4 08-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

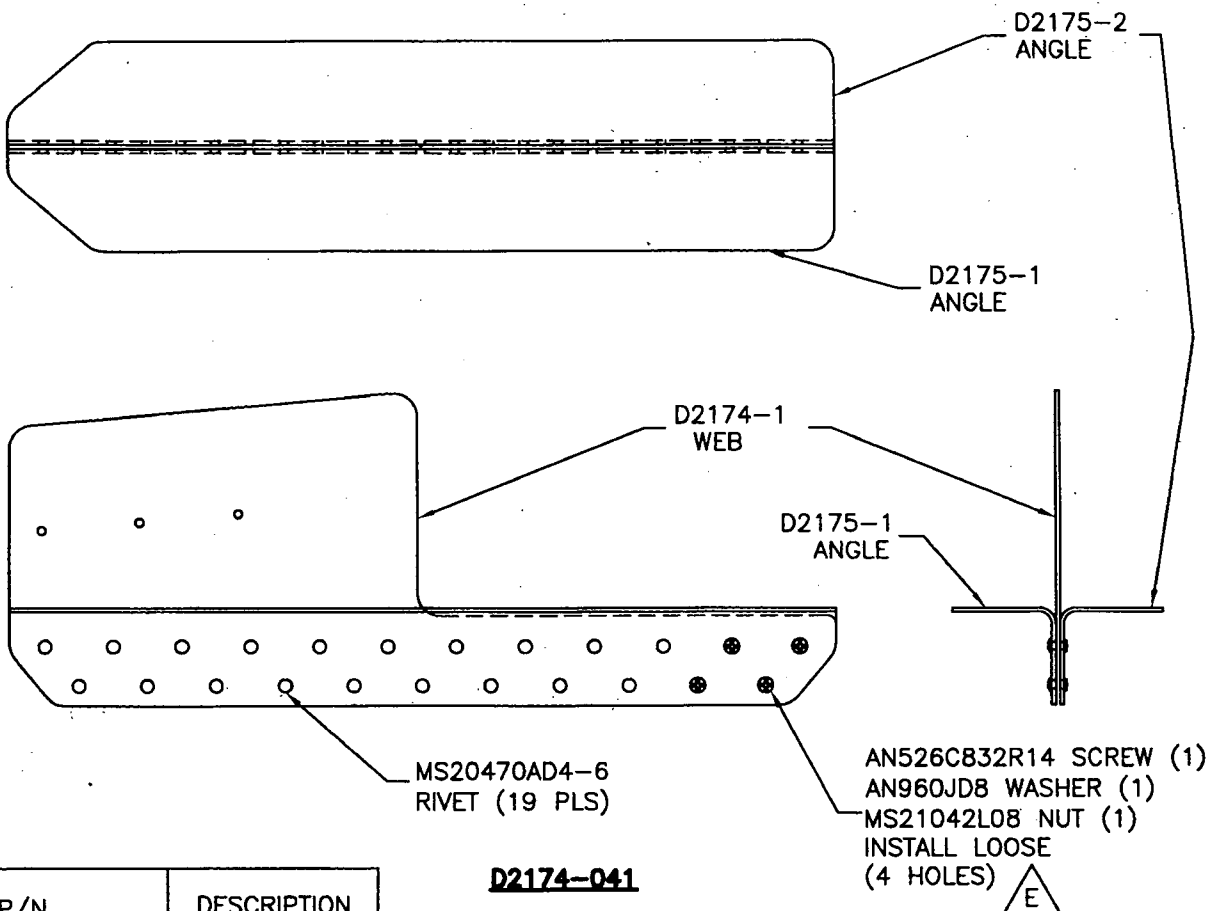
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
RF	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D2174	SHEET 1 OF 2
DATE 06.09.25		TITLE WEB ASSEMBLY	SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



**D2174-041**

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

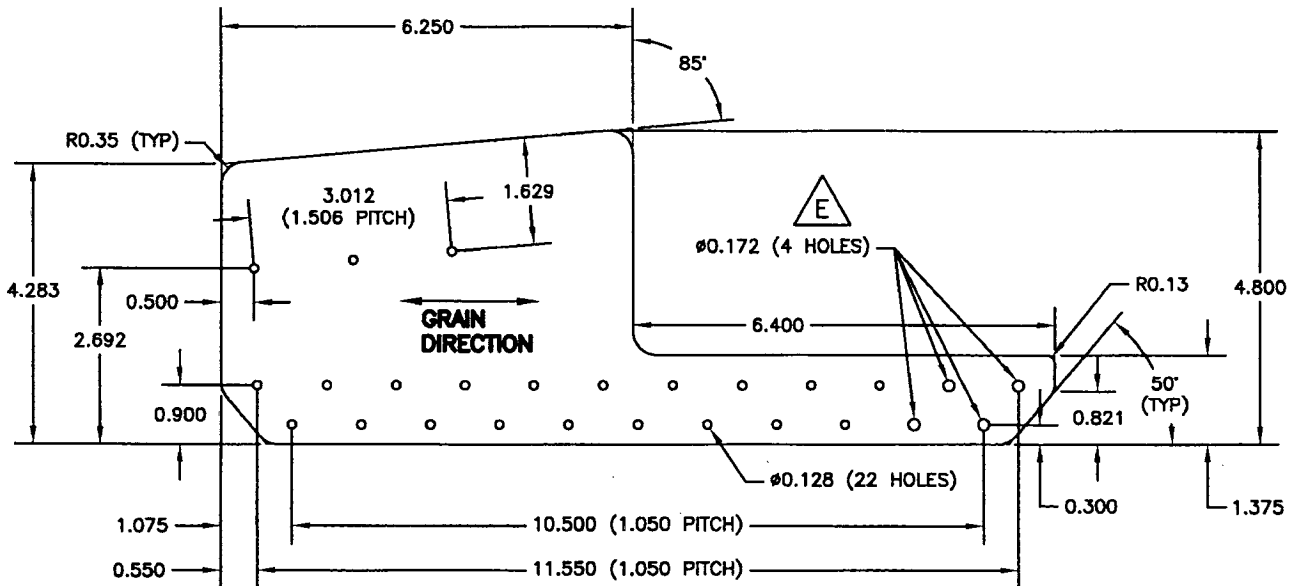
SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 27741  
WORK ORDER

RELEASED  
06.10.13



# DART

DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	[Signature]	REV. E
DATE	06.09.25	DRAWING NO.	D2174	SHEET 2 OF 2
		TITLE	WEB	SCALE
				1:3



**D2174-1**

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

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SUBJECT TO ATTENDMENT  
WITHOUT NOTICE  
WORK ORDER  
37741

RELEASED  
06.10.23

